
Tuesday, September 22, 2009 3:13:49 PM

Accept

Setup Start

Stop

**Cust Item ID:**

Customer:

Reference:

Run Start

Tooling:

Date:

QC:

Date: _____ **SPC (Y/N):** _____

Date:

Stop

**Insp.
Stamp**

Revision Nbr

D3276

Rev B

100

0.00

[illegible]

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3276 □Dwg Rev: B □Prog Rev: B □2-
Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00

[illegible]

Memo

0.00

Quality Control

120

QC8- Inspect parts - second check

0.00

Memo

0.00






Quality Control

Work Order ID 52373



Tuesday, September 22, 2009 3:13:49 PM






Page 2

Item ID: D3276-041 Accept  Setup Start 
Revision ID: B Stop 
Item Name: Baffle Assembly LH
Start Date: 9/23/2009 Start Qty: 4.00  Cust Item ID:
Required Date: 10/9/2009 Req'd Qty: 4.00  Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  Small Fab	Small Fab	0.00							
Small Fab	Memo	0.00							
Small Fab	1-Deburr□2-Roll as per Dwg D3276		SB 02/11/19						
140  Brake NC	NC BRAKE	0.00							
Brake NC	Memo	0.00	SB 09/11/19						
Brake NC	Form as per Dwg D3276								
150  QC	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00	SB 09/11/19						
Quality Control									

(04)
(16)

Work Order ID 52373

Tuesday, September 22, 2009 3:13:49 PM



Page 3

Item ID: D3276-041

Accept



Setup Start



Revision ID: B

Stop



Item Name: Baffle Assembly LH

Start Date: 9/23/2009 Start Qty: 4.00



Cust Item ID:

Required Date: 10/9/2009 Req'd Qty: 4.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

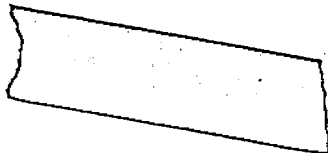


QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00	<i>90</i>	<i>09/11/23</i>		<i>(X6)</i>	<i>8</i>		
170 Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum <i>11112148</i> Memo START TIME: <i>1:45pm</i> OVEN TEMPERATURE: <i>2:15pm</i> FINISH TIME: <i>3:20pm</i>	0.00 0.00	<i>=7</i>	<i>del</i>	<i>09/11/23</i>	<i>(X6)</i>	<i>8</i>		
180 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00	<i>br</i>	<i>09-11-23</i>		<i>(6)</i>			



Work Order ID 52373

Tuesday, September 22, 2009 3:13:49 PM

Page 4

Item ID: D3276-041

Accept

Revision ID: B

Item Name: Baffle Assembly LH

Start Date: 9/23/2009 Start Qty: 4.00

Required Date: 10/9/2009 Req'd Qty: 4.00

Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

190

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

Assemble as per Dwg D3276

9/30/11/26 (6)

200

0.00



QCS- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

9/30/11/26

(6)

210

0.00



Identify as per dwg & Stock Location: 175

Packaging

Memo

0.00

Packaging

9/11/30 (6) 54

Work Order ID 52373

Tuesday, September 22, 2009 3:13:49 PM



Page 5

Item ID: D3276-041

Accept



Setup Start



Revision ID: B

Stop



Item Name: Baffle Assembly LH

Start Date: 9/23/2009 Start Qty: 4.00



Cust Item ID:

Required Date: 10/9/2009 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

220

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/11/30 *JA**PK 09-11-30**(4)*

Picklist Print

Tuesday, September 22, 2009 3:13:48 PM

Page 1

Work Order ID: 52373



Parent Item: D3276-041RevB



Parent Item Name: Baffle Assembly LH

Start Date: 9/23/2009

Required Date: 10/9/2009

Comments:

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3276-3RevB

Manufactured

No

100

Each

9.0000

4.0000



Decal

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

9

44306

9

D2464RevB

Manufactured

No

190

f

807.2500

9.0000



3/4 Seal

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

807.25

39669

101.24

48173

706.01

EP 09/11/26

6
EP 09/11/26

13.5

Picklist Print

Page 2

Tuesday, September 22, 2009 3:13:48 PM

Work Order ID: 52373



Parent Item: D3276-041RevB



Parent Item Name: Baffle Assembly LH

Start Date: 9/23/2009

Required Date: 10/9/2009

Comments:

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6S.040		Purchased	No			190	sf	114.0568	4.2968			
6061-T6 .040 Sheet												

B 9-10-08

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

114.0568

100742

3.3

102723

7.93

105842

12

106747

12.5

107461

13.1642

109396

22.28

111224

41.3826

19380

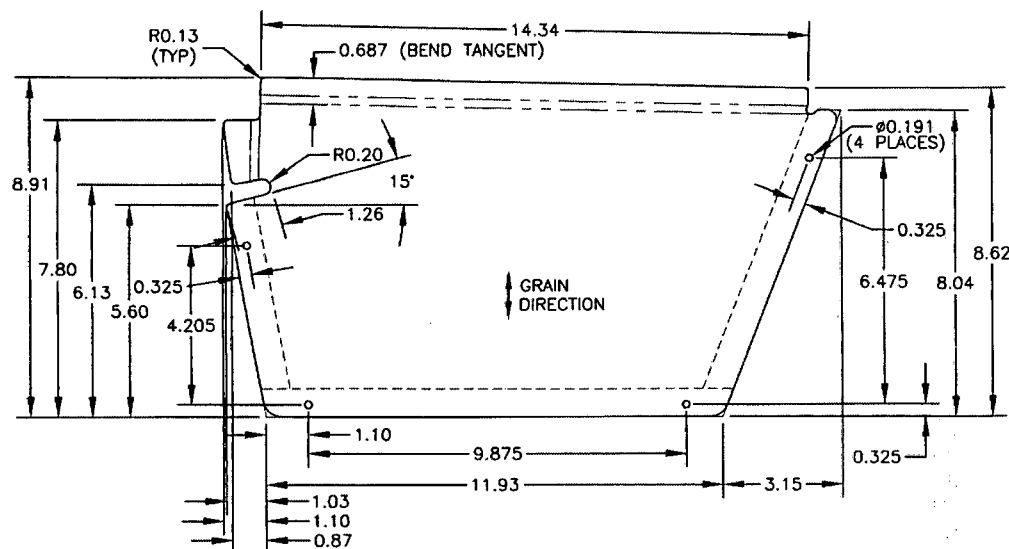
1.5

113004

113004

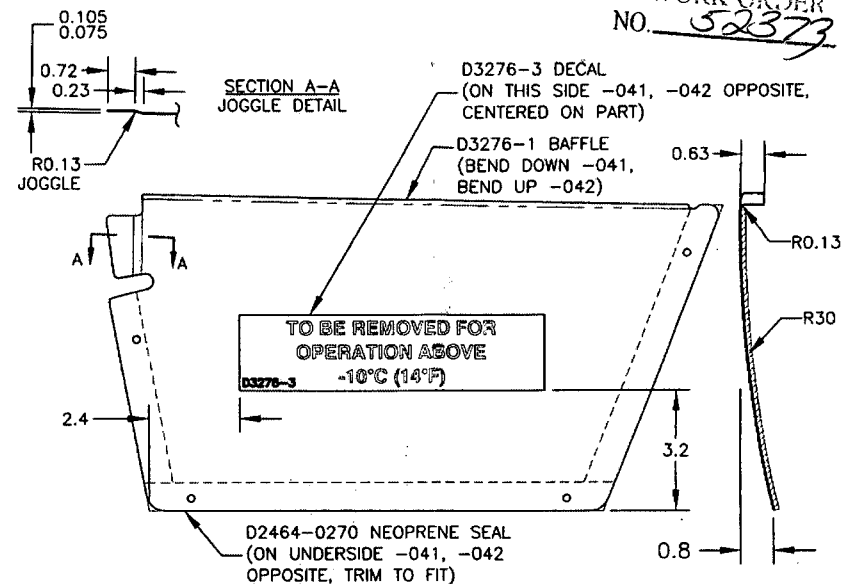
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER
NO. 52373

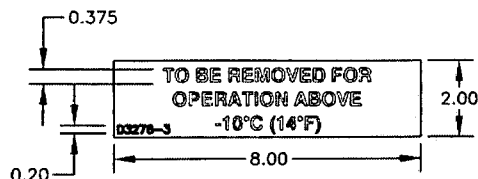


D3276-1 BAFFLE (FLAT PATTERN)

- 1) MACHINE PER DWG FILE "D3276-A.DWG"
- 2) MATERIAL: 6061-T6 ALUMINUM 0.040 THICK (QQ-A-250/11)
(REF DART SPEC. M6061T6S.040)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



D3276-041 BAFFLE ASSEMBLY, LH (SHOWN) D3276-042 BAFFLE ASSEMBLY, RH (BEND/JOGGLE OPPOSITE)



D3276-3 DECAL

- 1) RED LETTERING ON WHITE ADHESIVE BACK
- 2) MANUFACTURE FROM 3M 7 MIL MASKING FILM #8522CP OR AVERY IPM #2031
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
05.02.07

COPYRIGHT © 2004 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

B	05.01.25	LABEL NOW -10°C; CURVE PART
A	05.01.07	NEW ISSUE
DESIGN	CP	DRAWN BY CP
CHECKED	APPROVED	DART DART AEROSPACE LTD. MARKHAM, ONTARIO, CANADA
DATE	05.01.25	DRAWING NO. D3276
		TITLE BAFFLE ASSEMBLY
		REV. B SHEET 1 OF 1 SCALE 1:3